



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3492-5
Job Sheet 170276



Part No: D3492-5

Job Qty: 20 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		1/25/18	0.00	0.00	Start Up Machining-2		JB DAS
100	Hardinge	20 pcs		1/25/18	0.00	0.81	Hardinge		23
110	QC	20 pcs		1/25/18	0.00	0.00	QC2 Machining-2		9-89
120	QC	20 pcs		1/25/18	0.00	0.00	QC8 Machining-2		FK-18-2-2
150	HandFinish	20 pcs		1/25/18	0.00	0.07	HandFinish1		18-02-05
160	Powdercoat	20 pcs		1/26/18	0.00	0.03	Powdercoat1		OK 18-02-05
170	QC	20 pcs		1/26/18	0.00	0.00	QC3		11 FEB 0
180	Packaging	20 pcs		1/26/18	0.00	0.00	Packaging3-1		9-89 M 18-02-06
190	QC21-SA	20 Ea		1/26/18	0.00	0.00	QC21		DAS FEB 0 6 2018

Part Op 100 - 1-Turn as per Folio FA634 & Dwg D3492

Descriptions: 160 - (Flat End Only) START TIME: 2:00 FINISH TIME: 2:55 O.V.T. 3:25 1/18/18

180 - LOCATION : FP001

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R0.375	1	66	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.375inches ± 0.010	0.385 0.365		
2	Plug	0.188inches + 0.005 - 0.001	0.193 0.187		
3	Plug	0.045inches + 0.000 - 0.002	0.045 0.043		
4	Plug	0.500inches ± 0.010	0.510 0.490		
5	Plug	0.060inches ± 0.005	0.065 0.055		
6	Plug	0.060inches ± 0.005	0.065 0.055		
7	Plug	0.090inches + 0.000 - 0.002	0.090 0.088		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fal			
Date : _____		Step #: _____		QTY Effe			
Description Work Order Deviation							
Root Cause							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cur	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incom	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incom	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐				
				OTHER : _____			

Plug

S038391
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CANADA
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Start up Operation 02/02/18
Job No: 170276

PART NO: D3492-5
Original Serial #: S038391
Revision:
Operation:
Change No:

☐ Misaligned/off center
☐ Turning Sequence